

GROUP 3

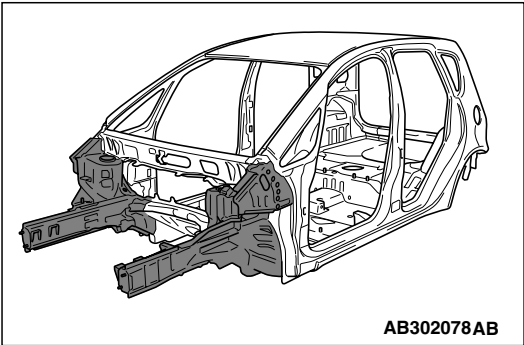
WELDED PANEL
REPLACEMENT


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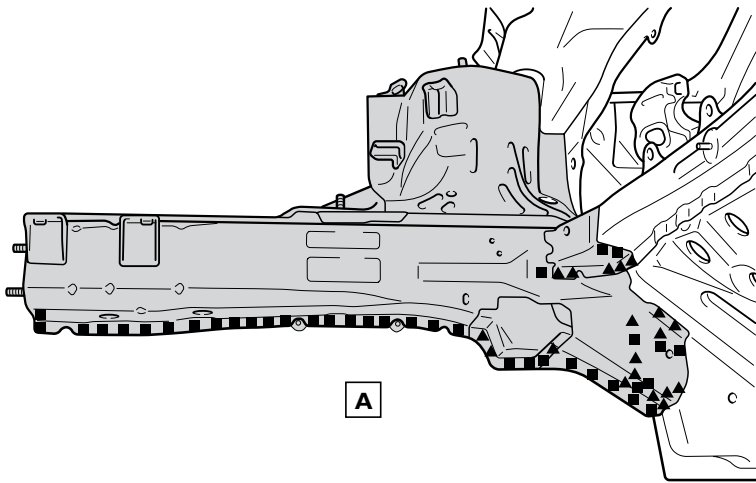
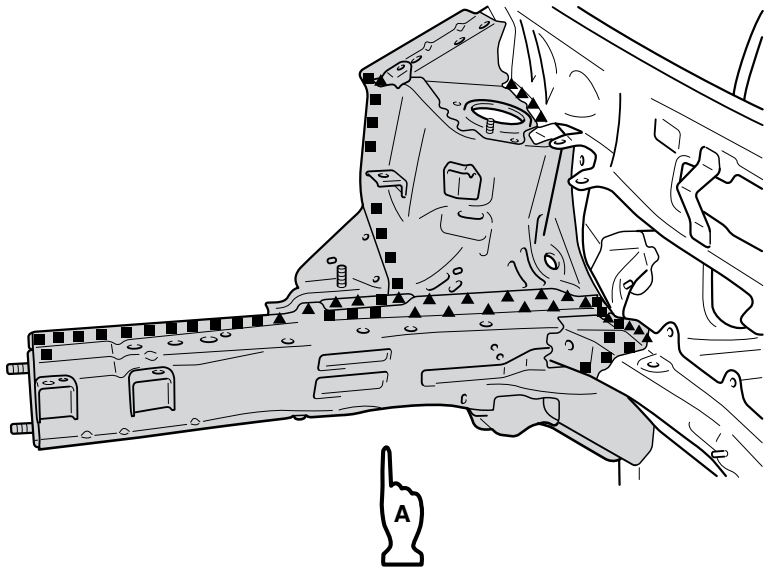
FENDER SHIELD

M4030004000288

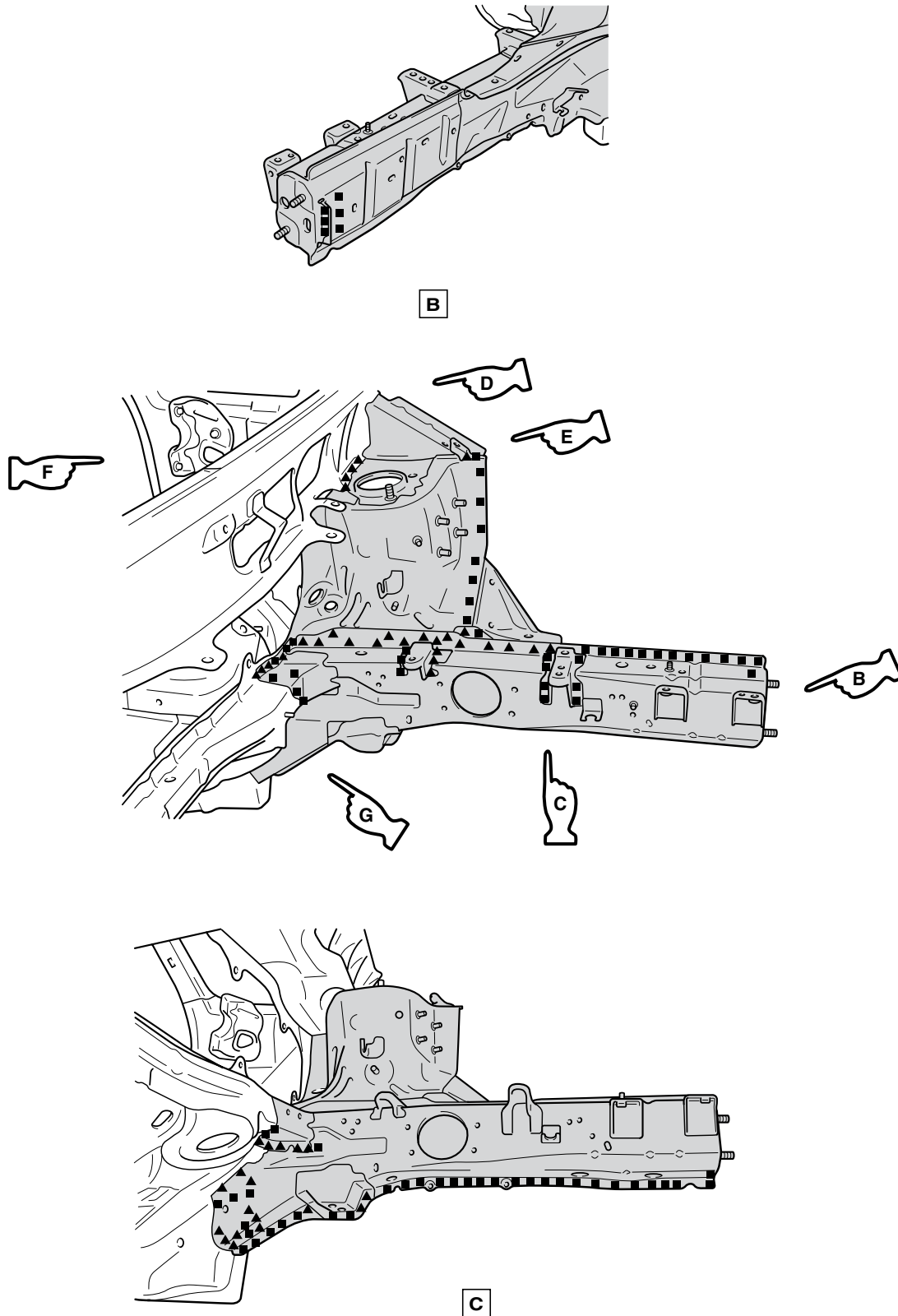


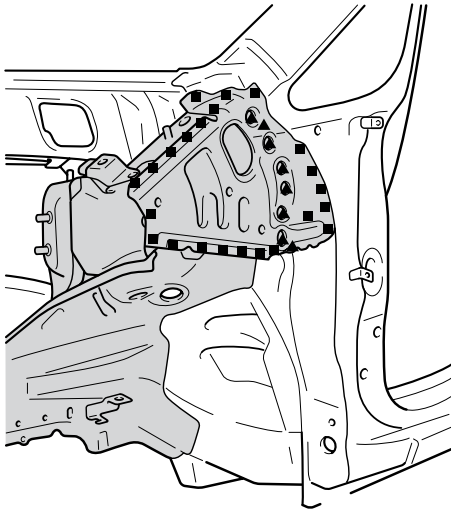
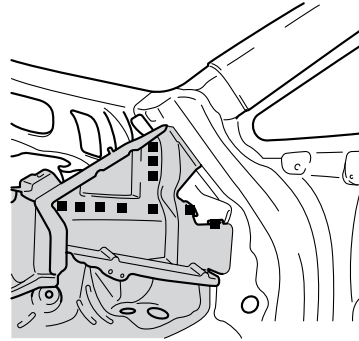
| Symbol | Operation description |
|---|--|
| ● ● ● ● | Spot welding |
| ■ ■ ▲ ▲ | MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded) |
| + + + + | MIG spot welding |
| | MIG arc welding (continuous) |
| ooooooo | Braze welding |
|  | Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.) |

REPAIR WELDS

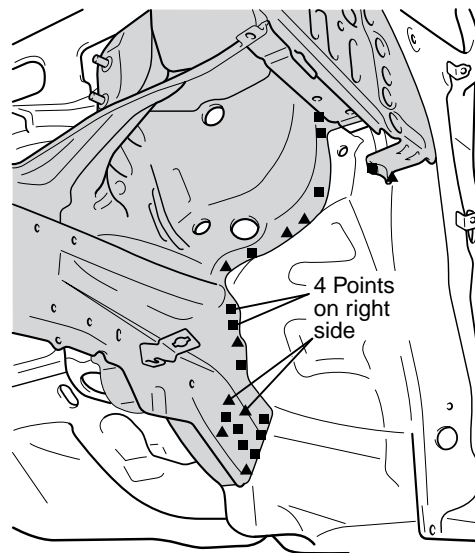


AB302101AB



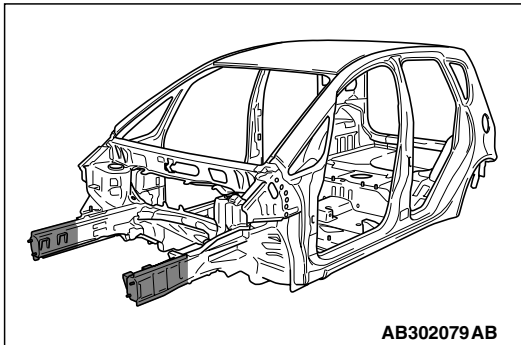
**D****E**

(With the Front deck frame upper outer removed)

**F****G**

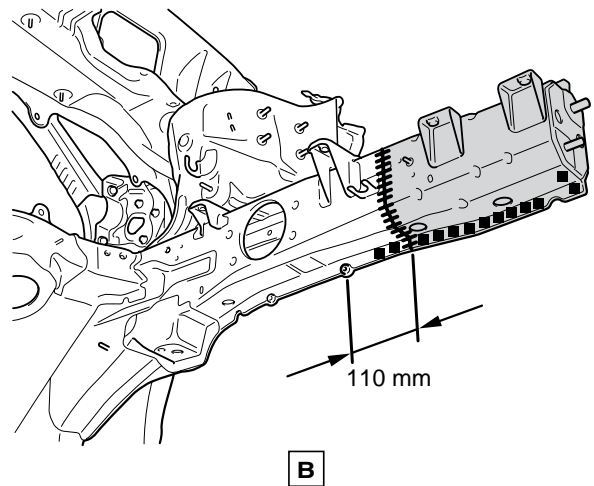
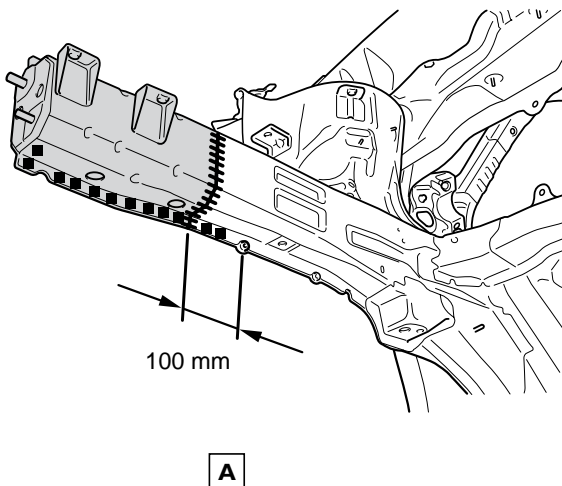
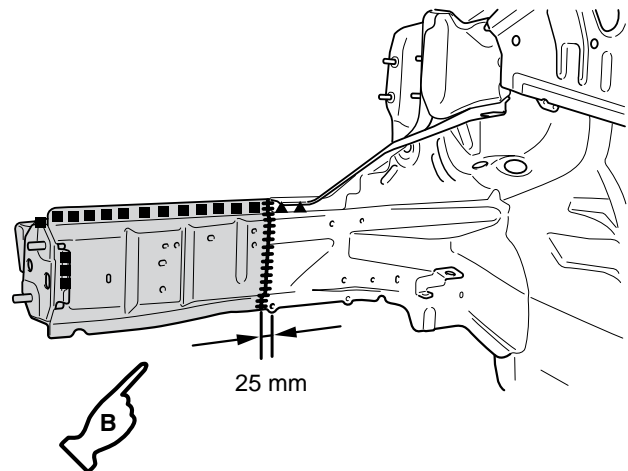
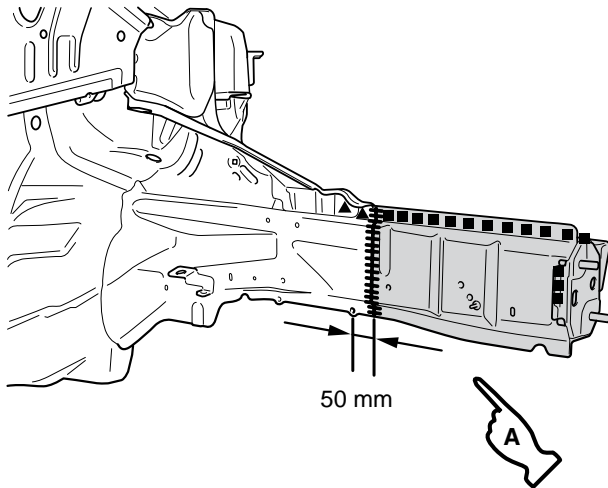
FRONT SIDEMEMBER (PARTIAL REPLACEMENT)

M4030000100186



| Symbol | Operation description |
|---------|--|
| ● ● ● ● | Spot welding |
| ■ ■ ▲ ▲ | MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded) |
| ++++ | MIG spot welding |
| | MIG arc welding (continuous) |
| ooooo | Braze welding |
| | Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.) |

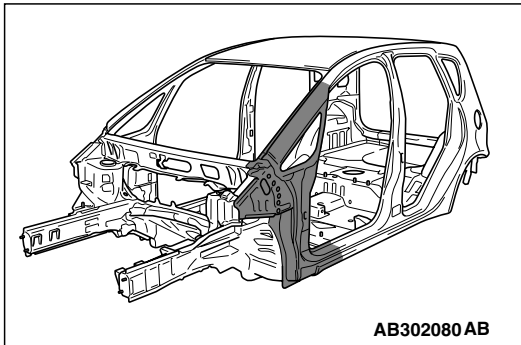
REPAIR WELDS



AB302131AB

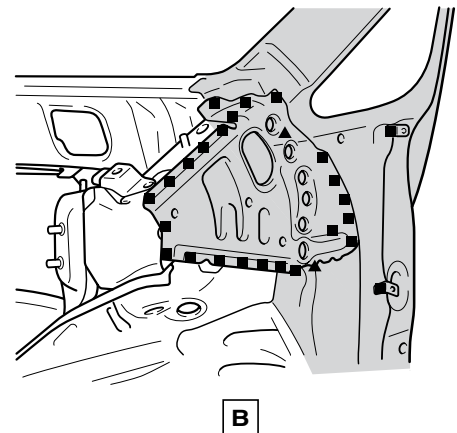
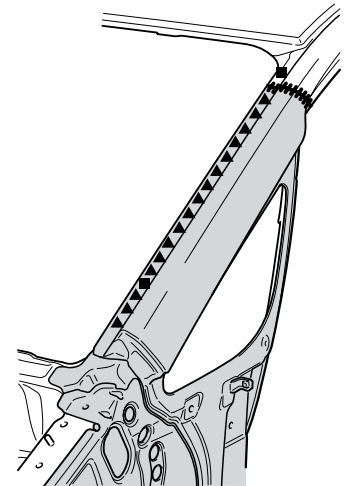
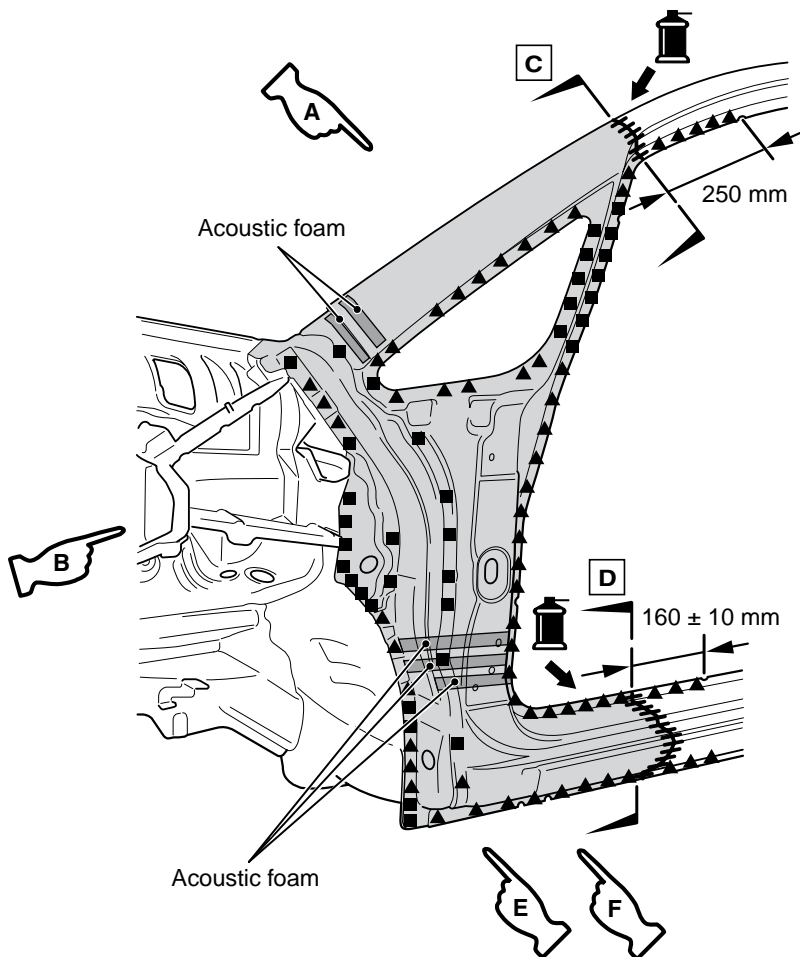
FRONT PILLAR

M4030005000452



| Symbol | Operation description |
|---------|--|
| ● ● ● ● | Spot welding |
| ■ ■ ▲ ▲ | MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded) |
| ++++ | MIG spot welding |
| | MIG arc welding (continuous) |
| oooooo | Braze welding |
| | Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.) |

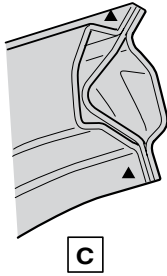
REPAIR WELDS



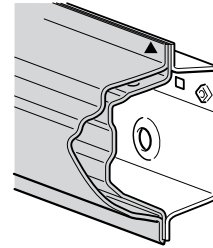
AB302111AB

CAUTION

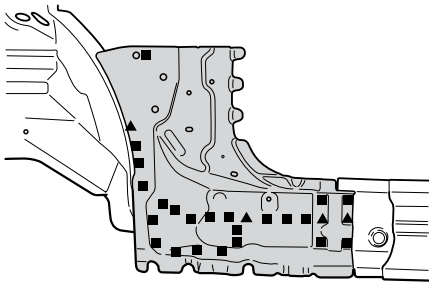
When repairing the area using foam materials do not use firing tools since the foaming materials may burn.



C

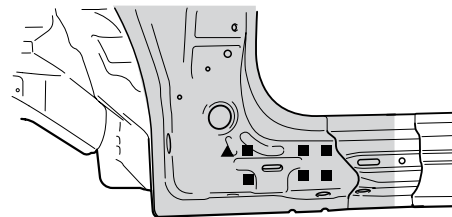


D



(With the side sill reinforcement removed)

E

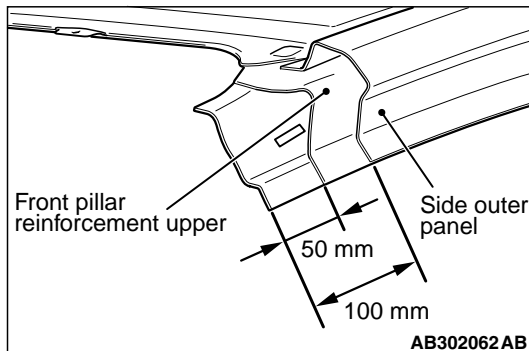


(With the side outer panel removed)

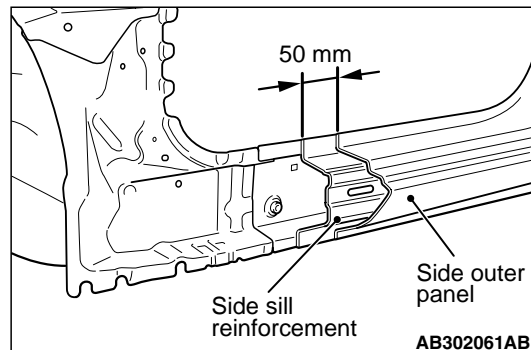
F

AB302155AB

**NOTE ON REPAIR WORK
INSTALLATION**



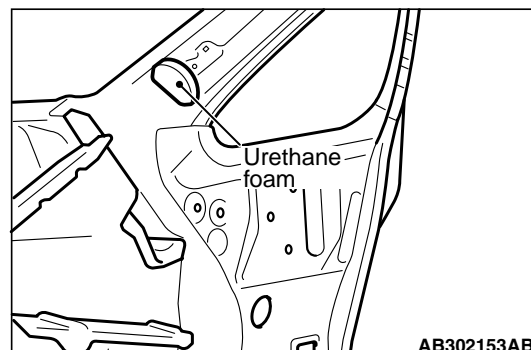
AB302062AB



AB302061AB

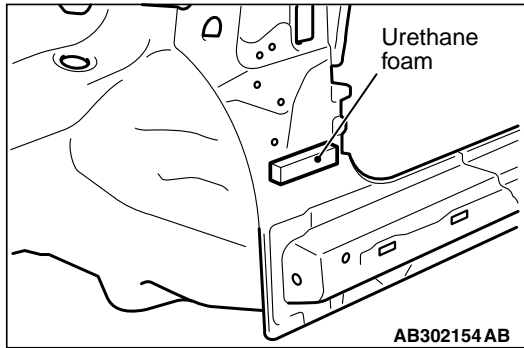
1. To reinforce the strength of the front pillar cut area, cut the side outer panel 100 mm above the cut-out area and front pillar reinforcement upper 50 mm above the cut-out area.

2. To reinforce the strength of the side sill cut area, cut the side outer panel 50 mm back from the cut-out area of side sill

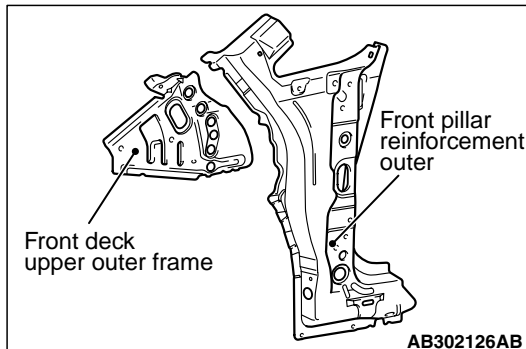


AB302153AB

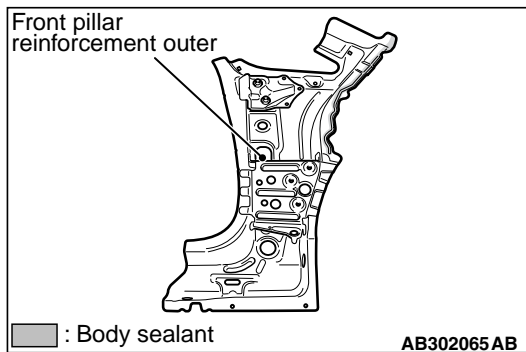
3. After assembling the front inner pillar, attach the urethane foam to the area shown in the figure in order to prevent foam materials from flowing out.



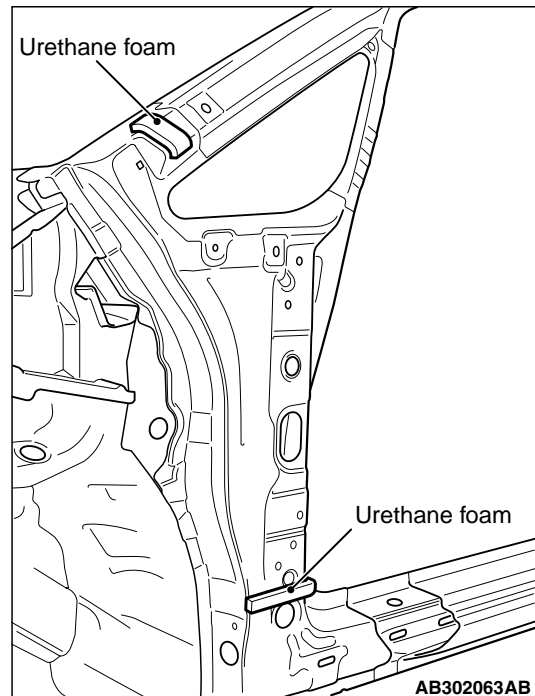
4. Before assembling the new front pillar reinforcement outer part, attach urethane foam to the area shown in the figure as an alternative to the foam material.



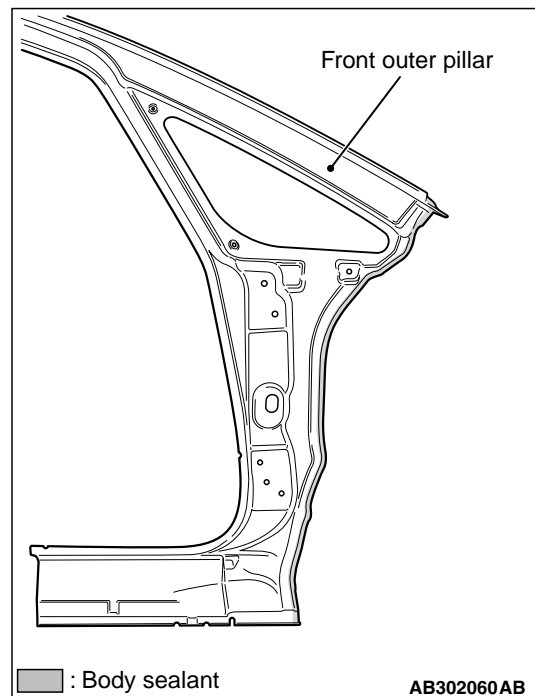
5. Remove the front deck frame upper outer from the new front pillar reinforcement part.



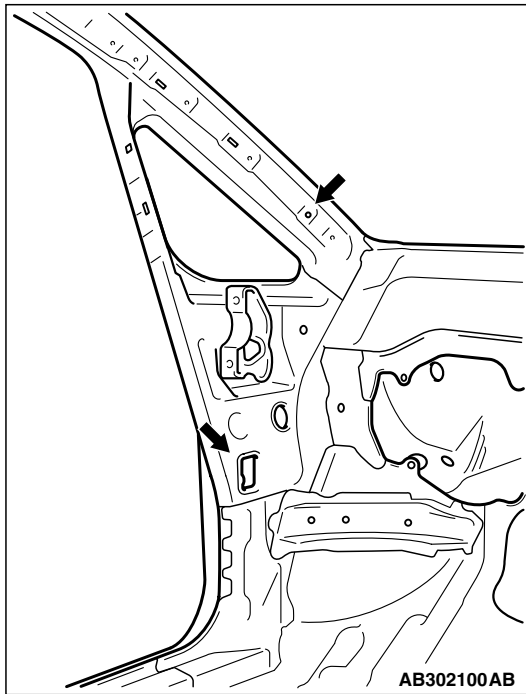
6. Apply in advance the body sealant in the areas shown in the figure when assembling the front pillar reinforcement outer.



7. Before assembling the new front out pillar part, attach urethane foam to the area shown in the figure as an alternative to the foam material.

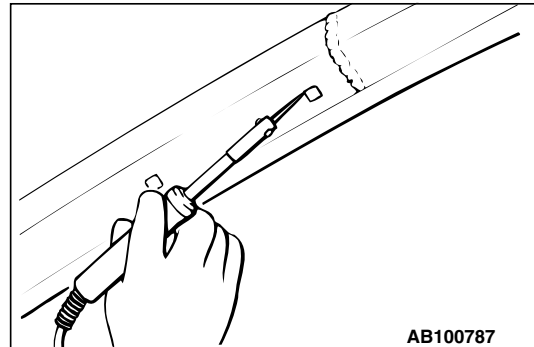


8. Apply in advance the body sealant in the area shown in the figure when assembling the front outer pillar.



9. Assemble the front outer pillar, seal the hole and flange with the bolt and plated tape, and fill the hole with foam materials as shown in the figure.

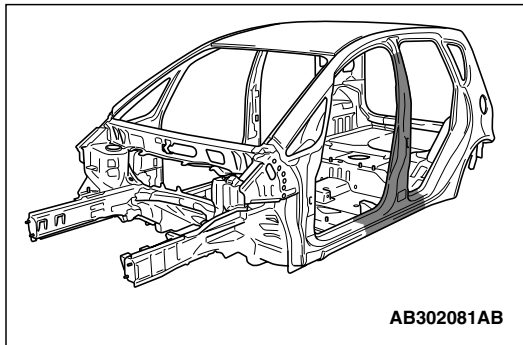
FOAM: 3M ATD ULTRAPRO Panel foam-Yellow




10. Wait 2 hours after filling the foam materials to remove the bolt and aluminium tape, then melt the foam materials with a soldering gun so a clip, etc. can thoroughly be inserted in the hole filled with foam materials.

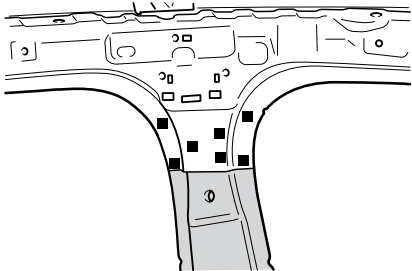
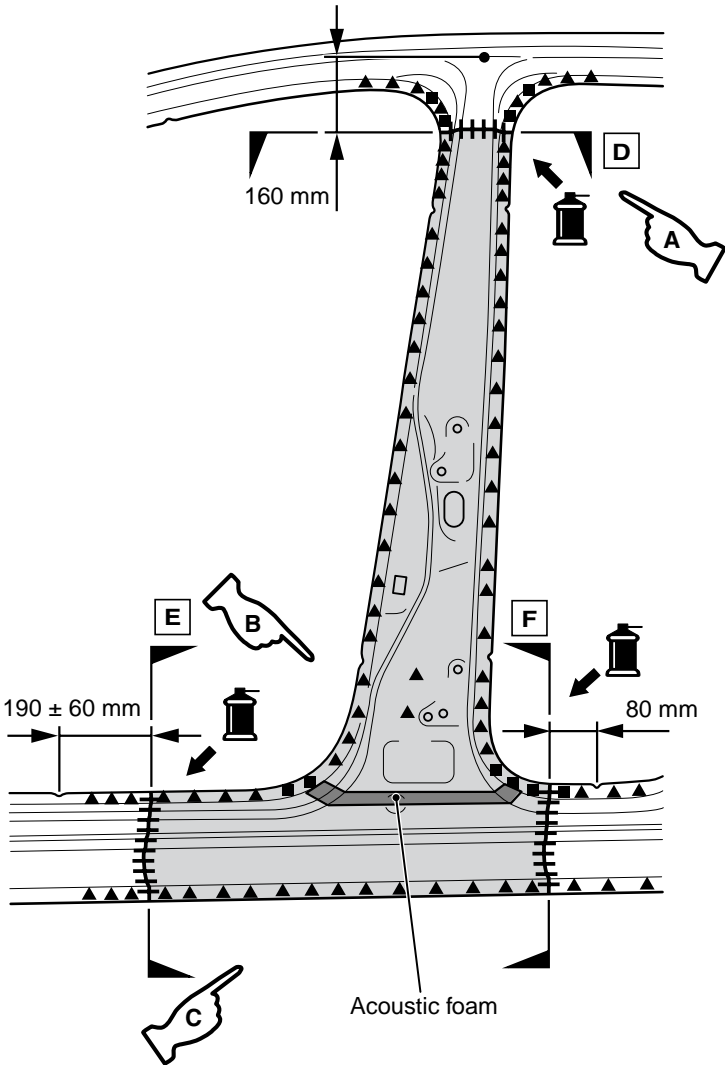
CENTRE PILLAR

M4030006000262

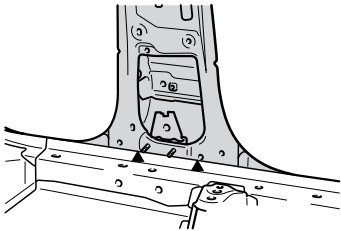


| Symbol | Operation description |
|---|--|
| ● ● ● ● | Spot welding |
| ■ ■ ▲ ▲ | MIG plug welding (■ : indicates two panels to be welded ▲ : indicates three panels to be welded) |
| ++++ | MIG spot welding |
| +++++ | MIG arc welding (continuous) |
| ooooooo | Braze welding |
|  | Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.) |

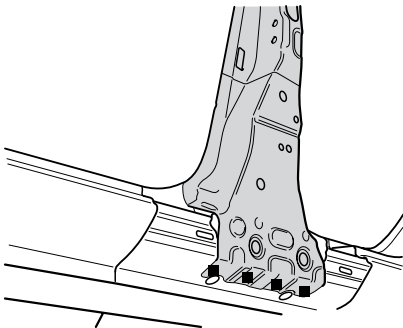
REPAIR WELDS



A



B

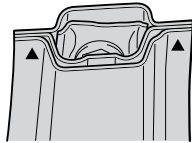


C

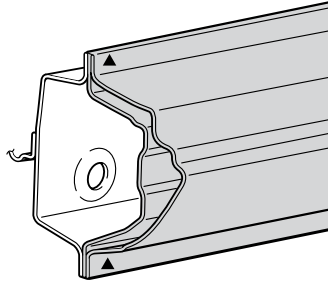
(With the side outer panel removed)

CAUTION

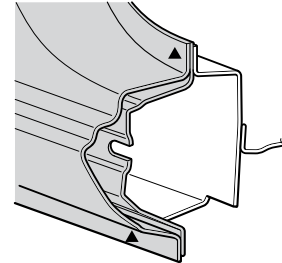
When repairing the area using foam materials do not use firing tools since the foaming materials may burn.



D



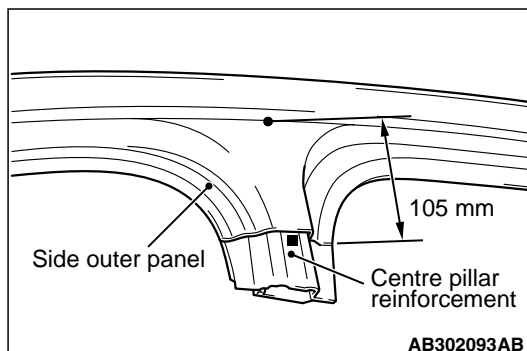
E



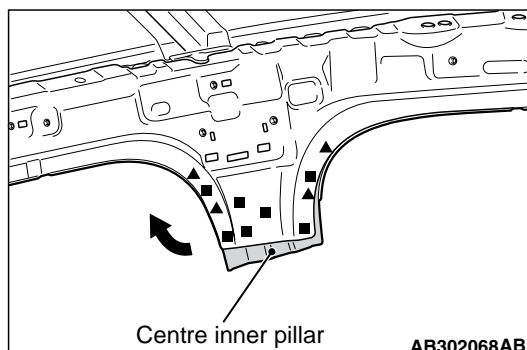
F

AB302156AB

**NOTE ON REPAIR WORK
REMOVAL**

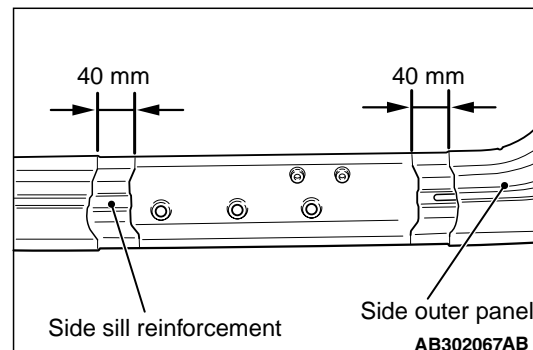


1. After cutting the centre pillar, cut the side outer panel 105 mm downwards from the position shown. Then, cut the welding point inside.



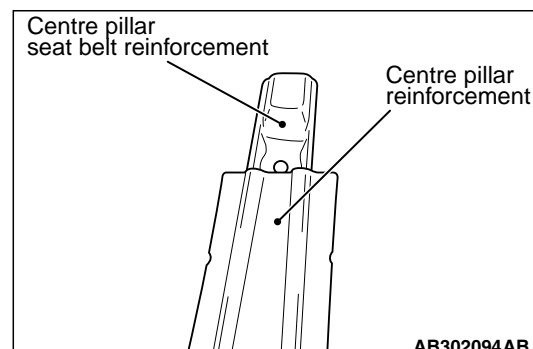
2. Cut the welding point shown and turn over the roof side rail inner. Then, remove the centre pillar seat belt reinforcement and remove the remaining centre inner pillar.

INSTALLATION



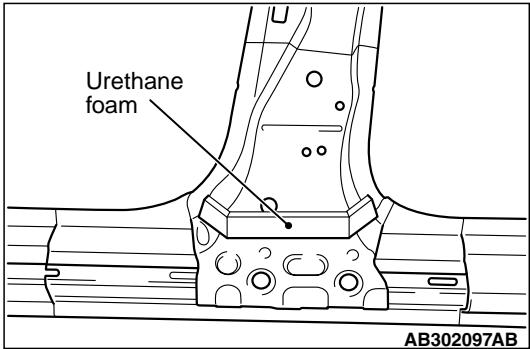
1. To reinforce the strength of the side sill cut area, cut the side outer panel in 2 locations of 40 mm forward and 40 mm back, both from the cut-out area of side sill.

CAUTION



Weld and repair the centre pillar seat belt reinforcement if it is damaged.

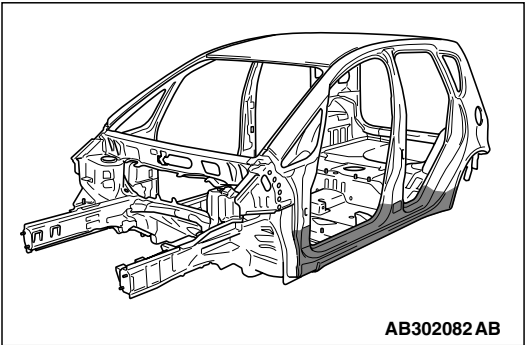
2. Assemble the centre inner pillar and the side sill reinforcement. Cut the centre pillar reinforcement, aligned with the body-side, of the new centre pillar reinforcement parts so the centre pillar seat belt reinforcement is not damaged.




3. After assembling the centre pillar reinforcement, adhere in advance urethane foam to the area shown in the figure as an alternative to the foam material.

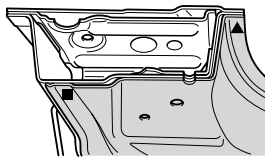
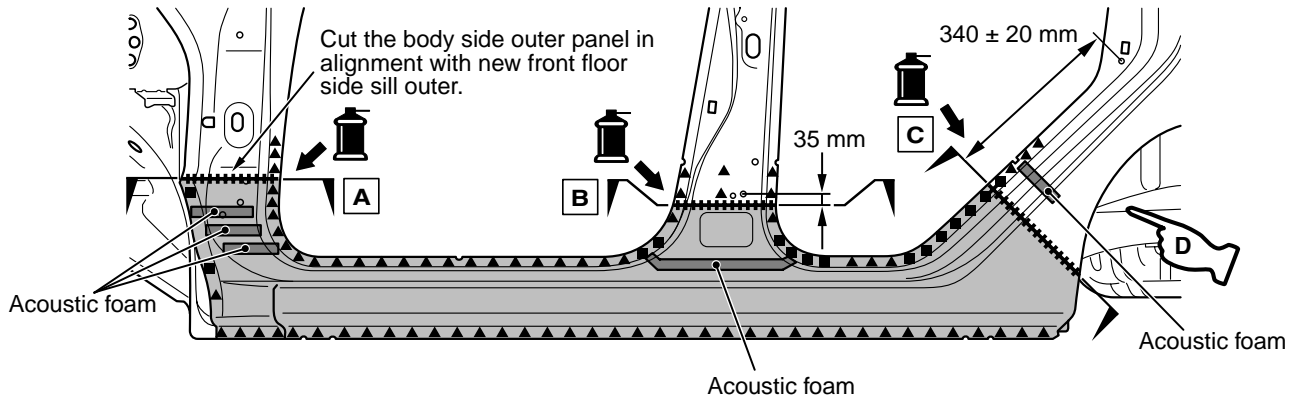
SIDE SILL

M4030007000287

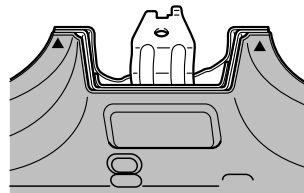


| Symbol | Operation description |
|--|--|
| ● ● ● ● | Spot welding |
| ■ ■ ▲ ▲ | MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded) |
| + + + + | MIG spot welding |
| | MIG arc welding (continuous) |
| ooooo | Braze welding |
|  | Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.) |

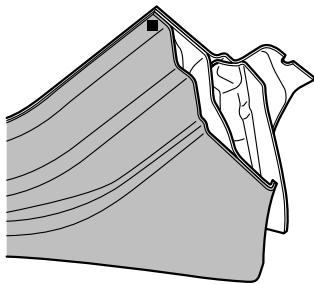
REPAIR WELDS



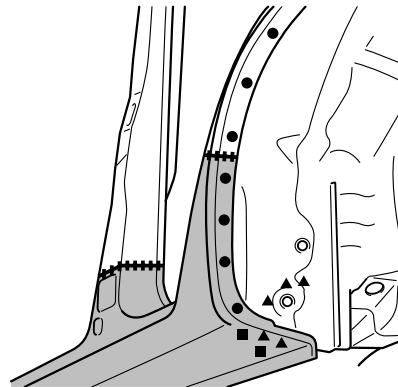
A



B



C



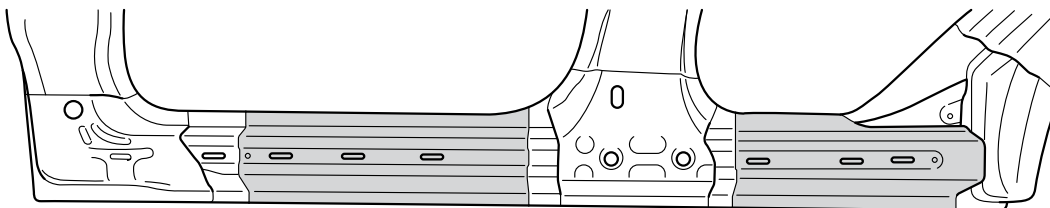
D

AB302134AB

CAUTION

When repairing the area using foam materials do not use firing tools since the foaming materials may burn.

Cut the side sill reinforcement within the range shown in the figure, and replace it.

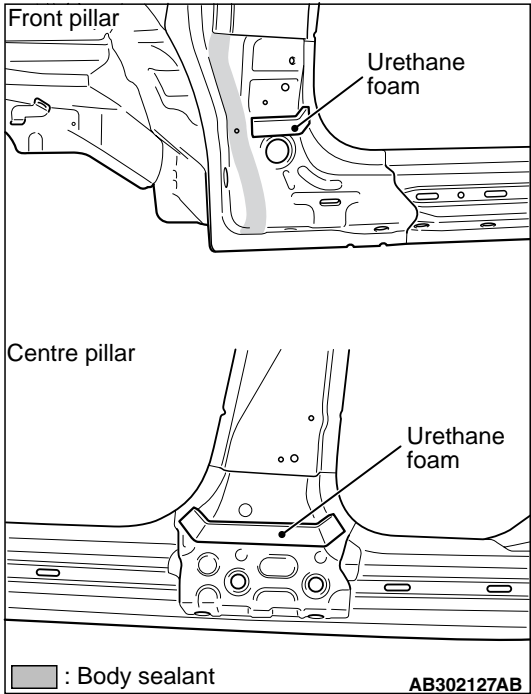


 : Cuttable range

(With the side outer panel removed)

AB302092AB

NOTE ON REPAIR WORK
INSTALLATION

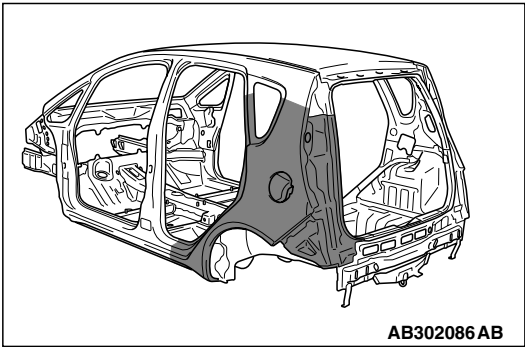



1. When assembling the front floor side sill outer, apply body sealant in the area shown in the figure of the front pillar. Attach in advance urethane foam to the front pillar and the centre pillar as shown in the figure as an alternative to the foam material.

NOTE: Partial replacement of side sill reinforcement is possible depending on the range of damage. Cut the side sill reinforcement so that it displaces 50 mm from the butt welding area with the side outer panel.

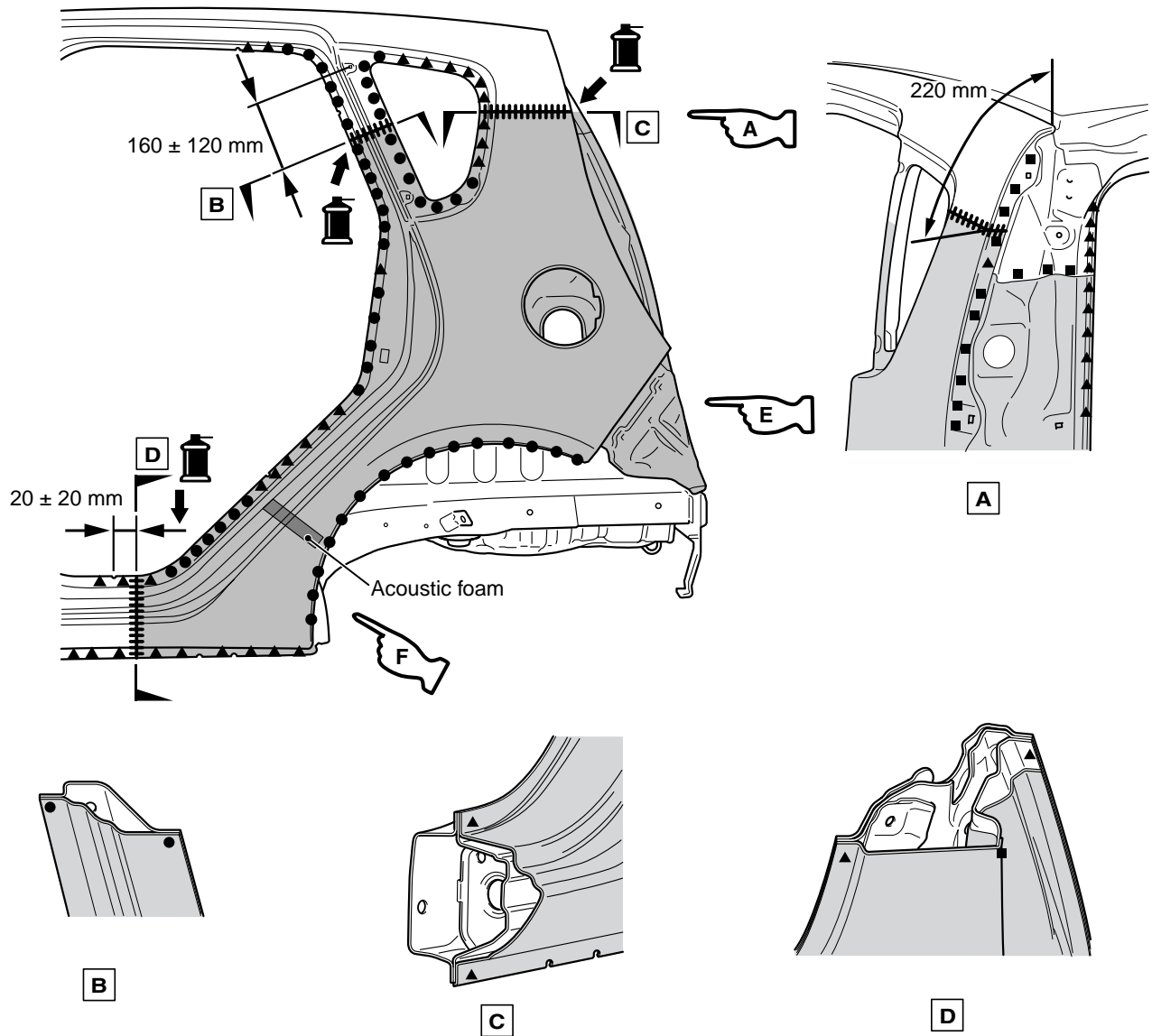
QUARTER, OUTER

M4030008000257

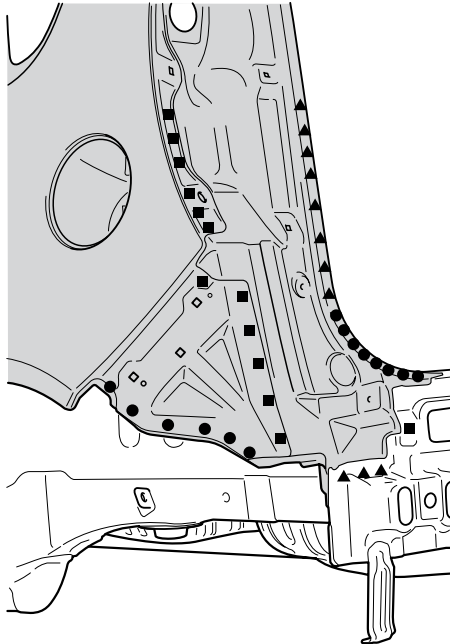


| Symbol | Operation description |
|---|--|
| ● ● ● ● | Spot welding |
| ■ ■ ▲ ▲ | MIG plug welding (■ : indicates two panels to be welded ▲ : indicates three panels to be welded) |
| + + + + | MIG spot welding |
| | MIG arc welding (continuous) |
| ooooo | Braze welding |
|  | Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.) |

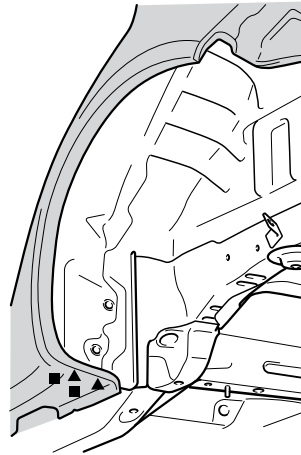
REPAIR WELDS



AB302119AB



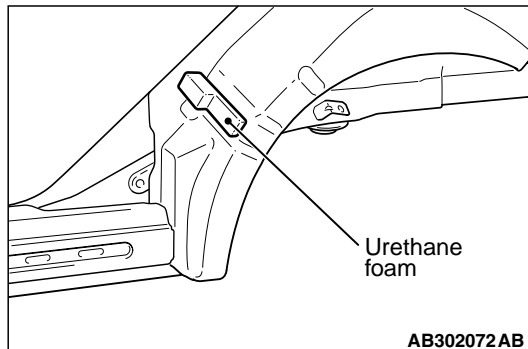
E



F

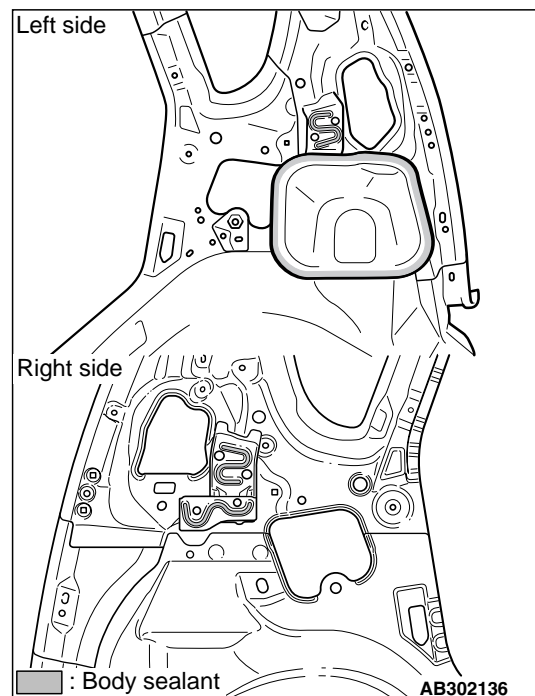
AB302120AB

NOTE ON REPAIR WORK INSTALLATION

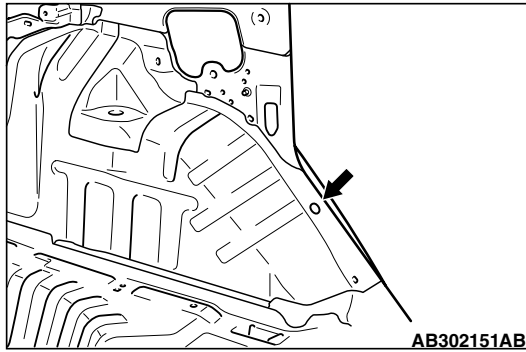


AB302072AB

1. Before assembling the quarter outer panel, attach urethane foam in the area shown to prevent the foam materials from flowing out.

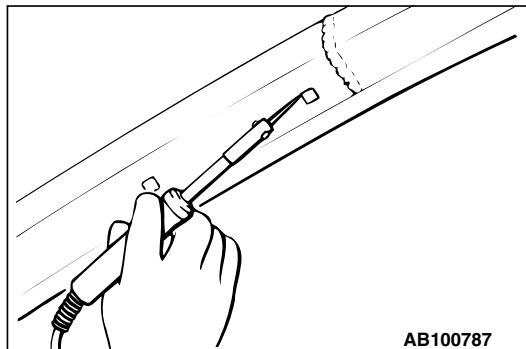


2. When assembling the quarter outer panel, apply in advance body sealant to the areas shown in the figure.



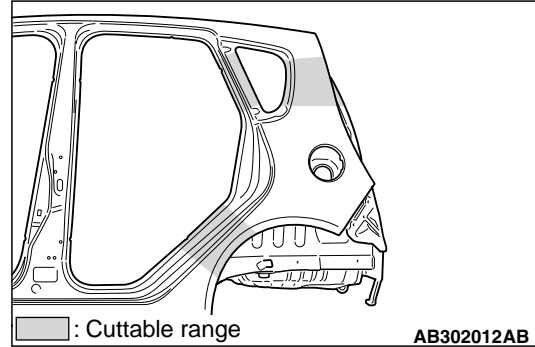
3. After assembling the quarter outer panel, seal the hole and flange with bolt and sheet-metal tape, and then fill the hole with foam materials as shown in the figure.

FOAM: 3M ATD ULTRAPRO Panel foam-Yellow



4. Wait 2 hours after filling the foam materials to remove the bolt and aluminium tape, then melt the foam materials with a soldering gun so a clip, etc. can thoroughly be inserted in the hole filled with foam materials.

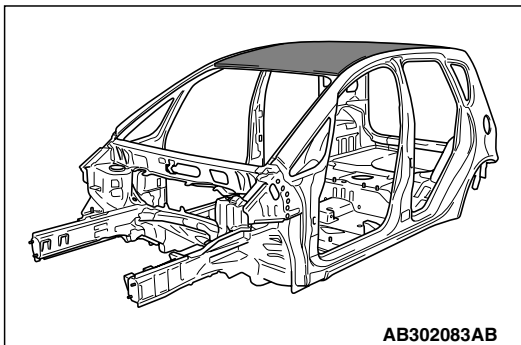
NOTE:



Partial replacement is possible depending on the range of damage.

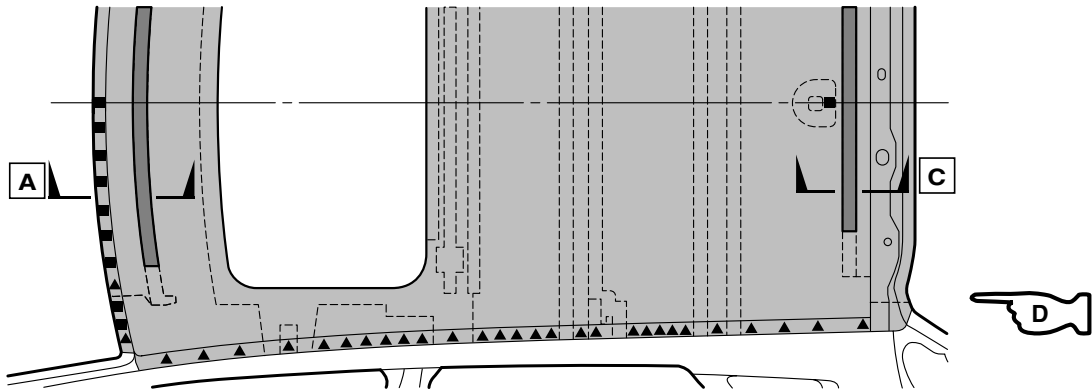
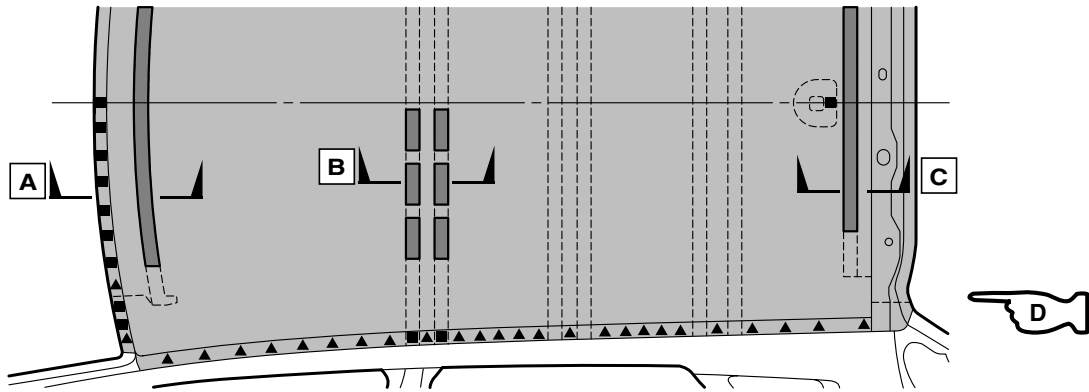
ROOF

M4030011000246



| Symbol | Operation description |
|---------|--|
| ● ● ● ● | Spot welding |
| ■ ■ ▲ ▲ | MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded) |
| ++++ | MIG spot welding |
| | MIG arc welding (continuous) |
| oooo | Braze welding |
| | Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.) |

REPAIR WELDS

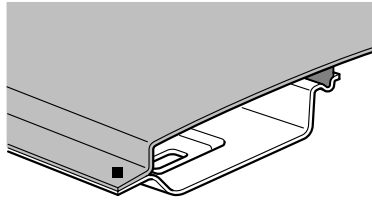


■ : Adhesive

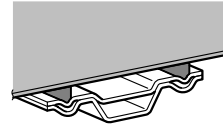
AB302146 AB

Adhesive: Urethane body sealer

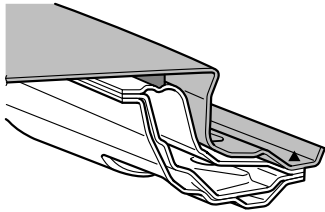
Brand: 3M ATD Part No.8542 or equivalent



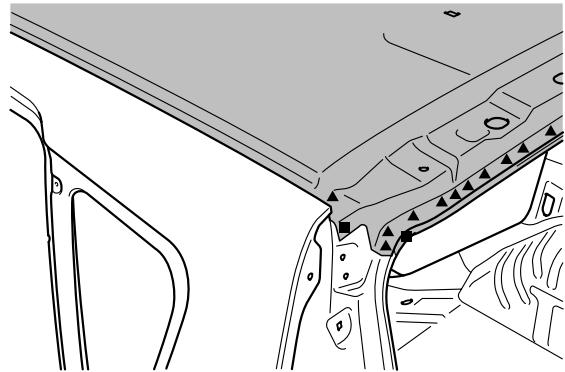
A



B



C

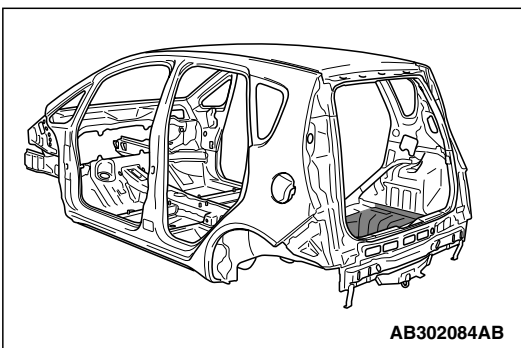



D

AB302147AB

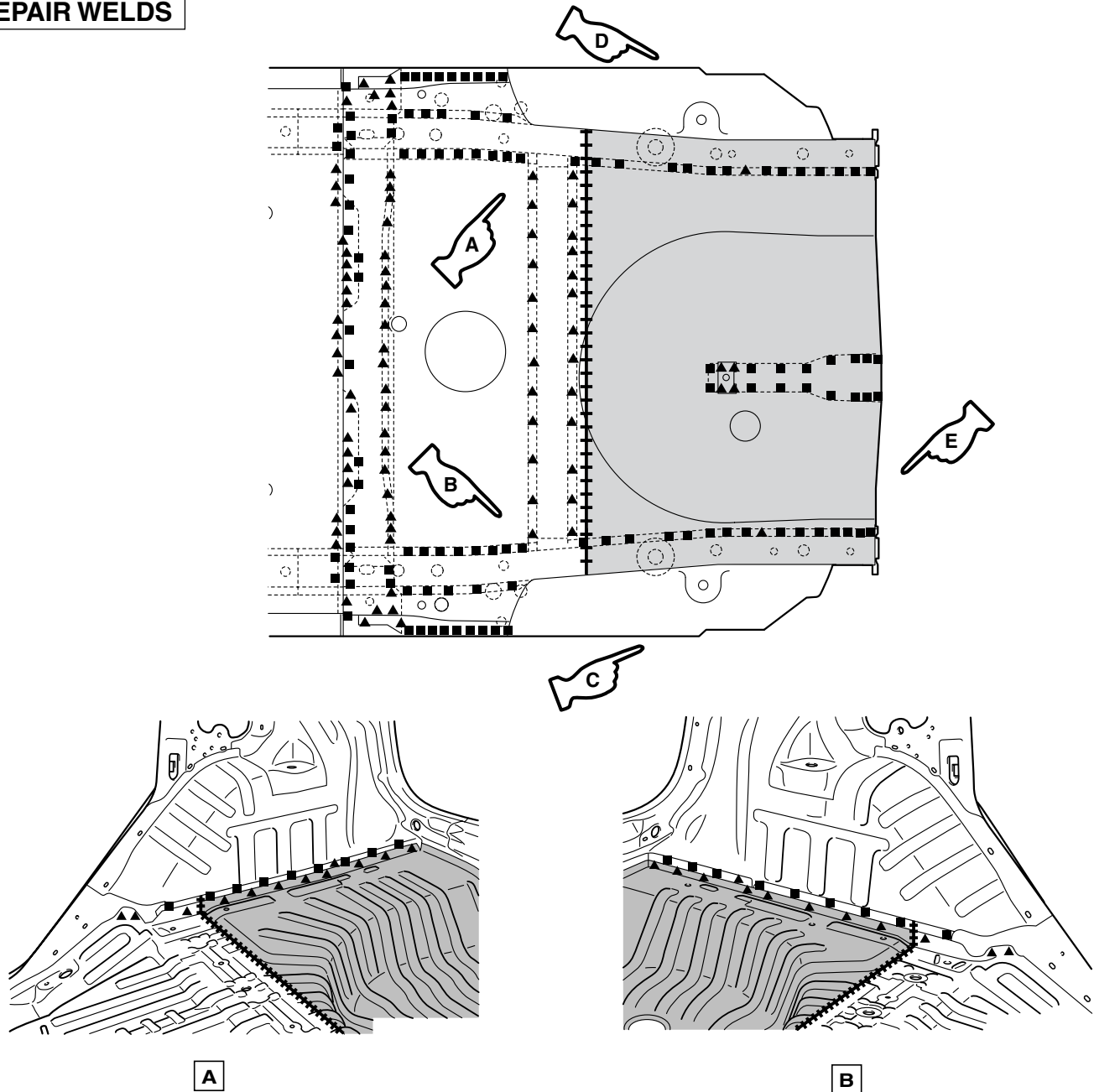
REAR FLOOR

M4030010000265



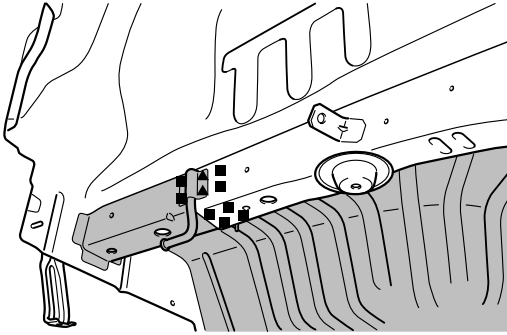
| Symbol | Operation description |
|---|--|
| ● ● ● ● | Spot welding |
| ■ ■ ▲ ▲ | MIG plug welding (■ : indicates two panels to be welded ▲ : indicates three panels to be welded) |
| + + + + | MIG spot welding |
| | MIG arc welding (continuous) |
| ooooo | Braze welding |
|  | Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.) |

REPAIR WELDS

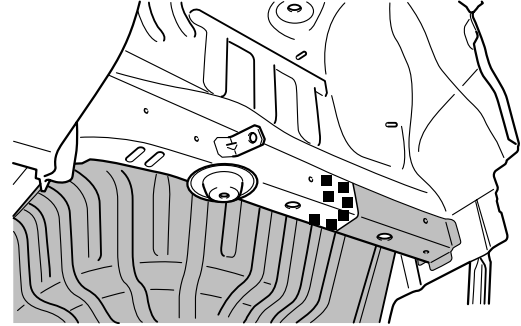


AB302128AB

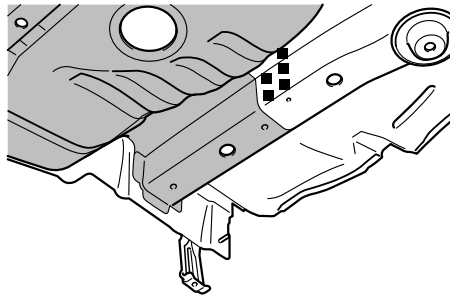
NOTE: Refer to the Rear End Panel Section on [P.3-22](#) for the welding points with the rear end panel.



C



D

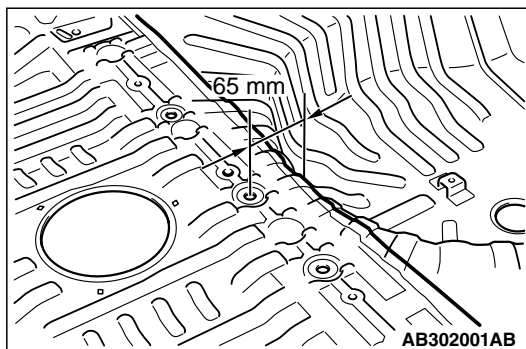


E

AB302152 AB

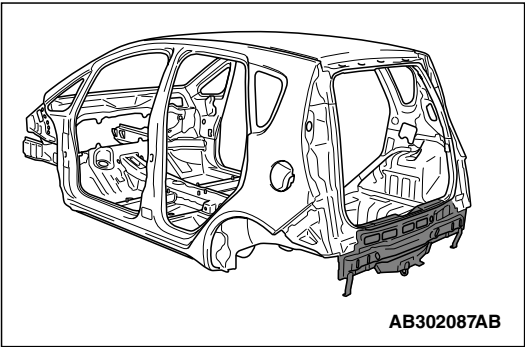
NOTE ON REPAIR WORK INSTALLATION


1. When cutting the rear floor, cut it 65 mm behind the floor carpet assembling hole as shown.



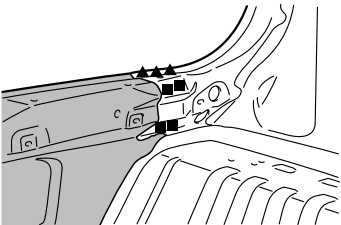
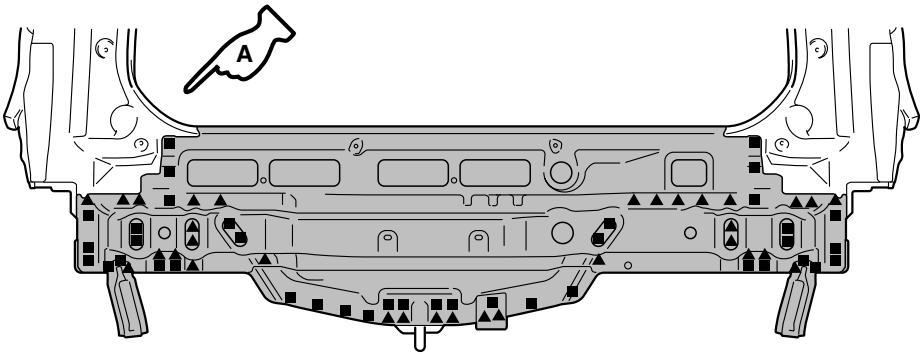
REAR END PANEL

M4030009000142



| Symbol | Operation description |
|---|--|
| ● ● ● ● | Spot welding |
| ■ ■ ▲ ▲ | MIG plug welding (■ : indicates two panels to be welded ▲ : indicates three panels to be welded) |
| + + + + | MIG spot welding |
| | MIG arc welding (continuous) |
| ○ ○ ○ ○ ○ ○ | Braze welding |
|  | Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.) |

REPAIR WELDS

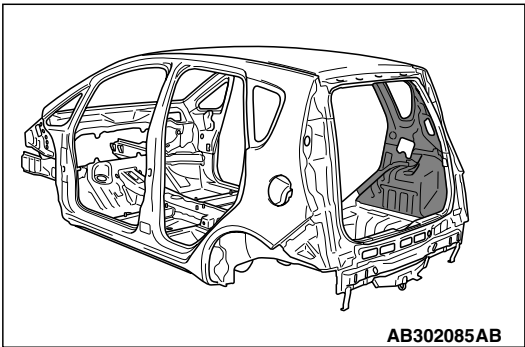



A

AB302107AB

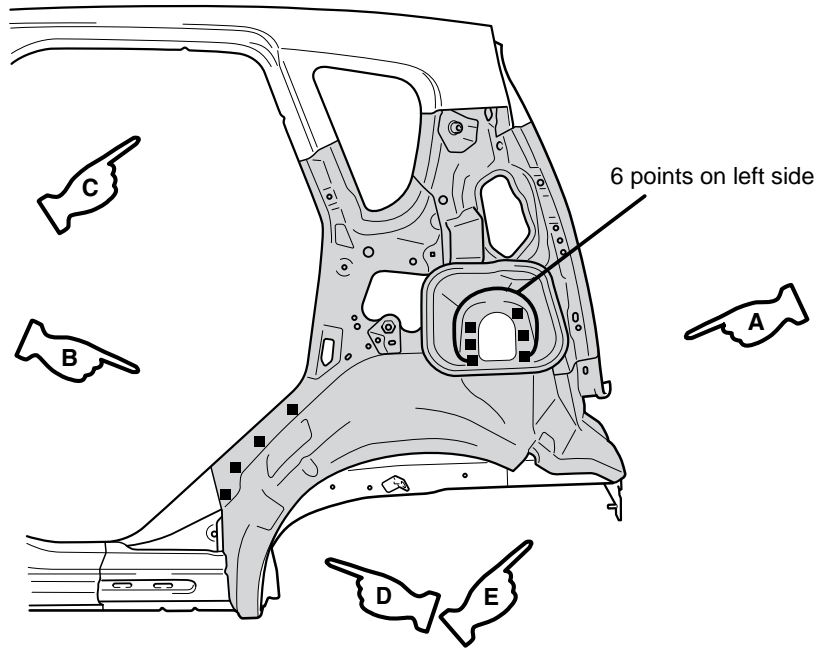
QUARTER, INNER

M4030012000250

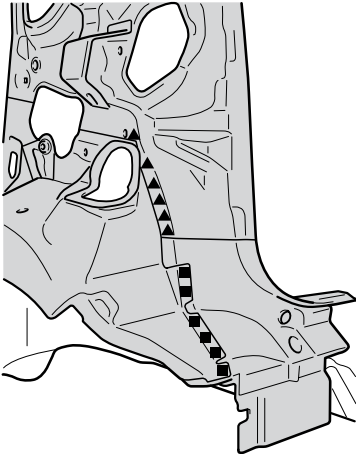


| Symbol | Operation description |
|---|--|
| ● ● ● ● | Spot welding |
| ■ ■ ▲ ▲ | MIG plug welding (■ : indicates two panels to be welded ▲ : indicates three panels to be welded) |
| + + + + | MIG spot welding |
| | MIG arc welding (continuous) |
| ○ ○ ○ ○ ○ ○ | Braze welding |
|  | Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.) |

REPAIR WELDS

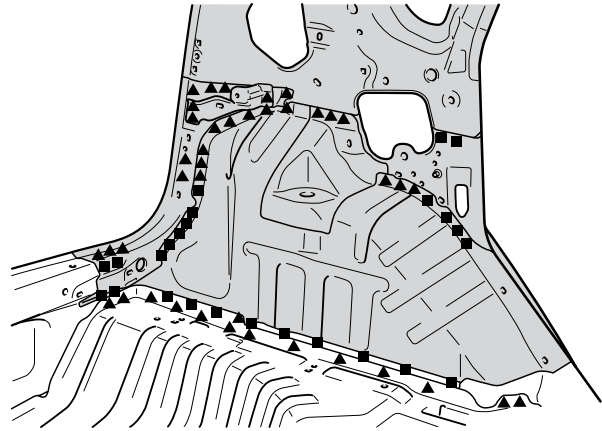


(With the quarter outer panel removed)



A

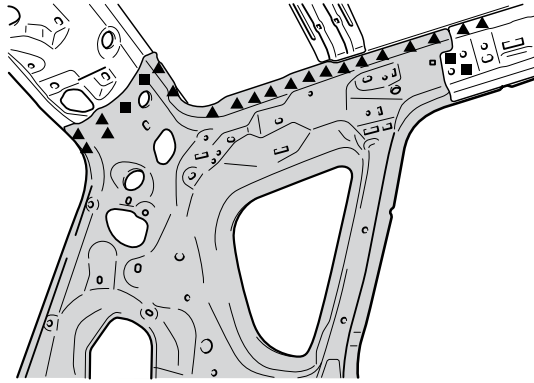
(With the fuel filler neck bracket removed)



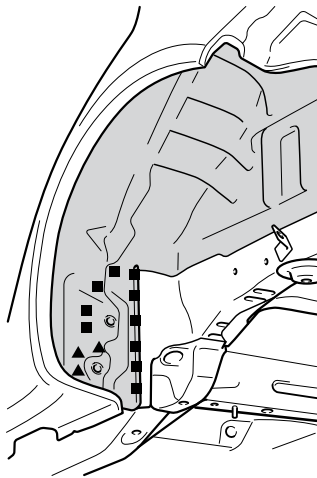
B

AB302129AB

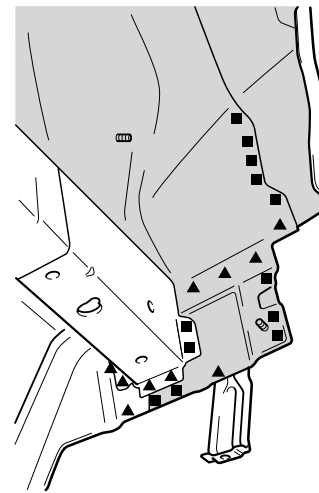
NOTE: Refer to the quarter outer Section on [P.3-14](#) for the welding point with quarter outer panel and rear combination lamp housing panel.



C



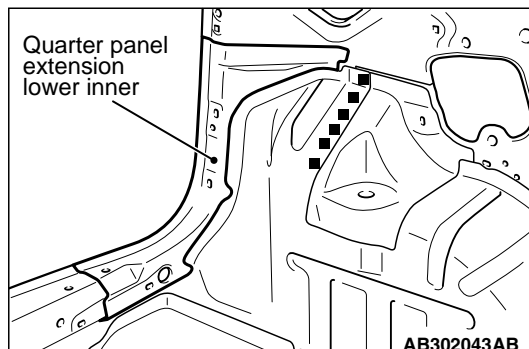
D



E

AB302130AB

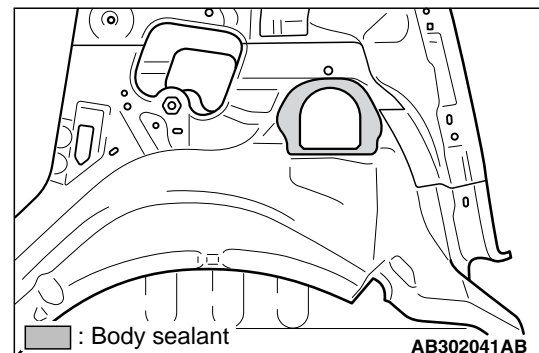
NOTE ON REPAIR WORK REMOVAL



AB302043AB

1. When removing the quarter panel extension lower inner, cut the welding points shown in the figure so that it is pulled out easily.

INSTALLATION

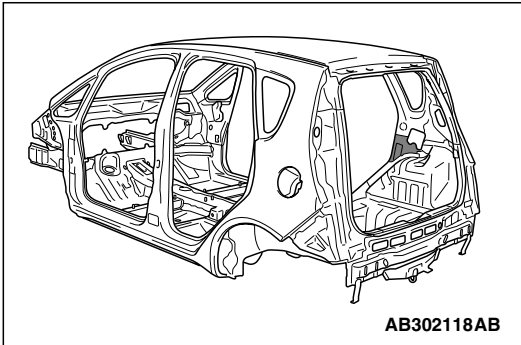


AB302041AB

1. When assembling the new fuel filler neck bracket, apply in advance body sealant to the areas shown in the figure.

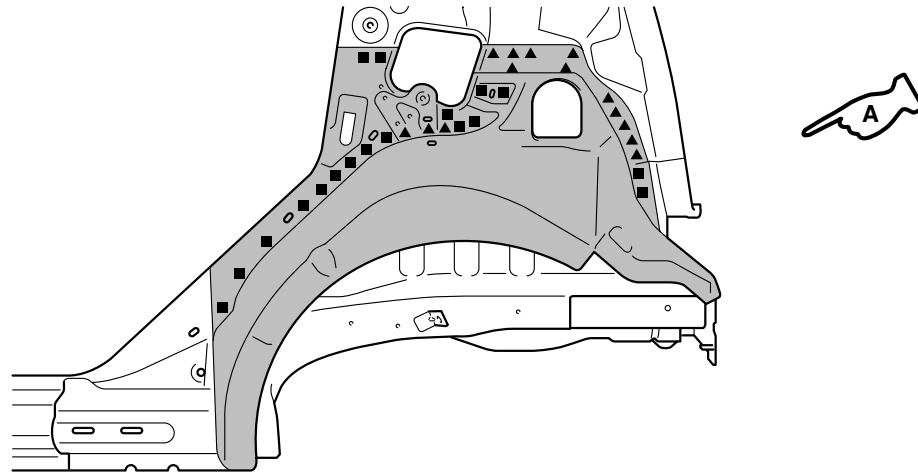
QUARTER INNER LOWER

M4030001100026

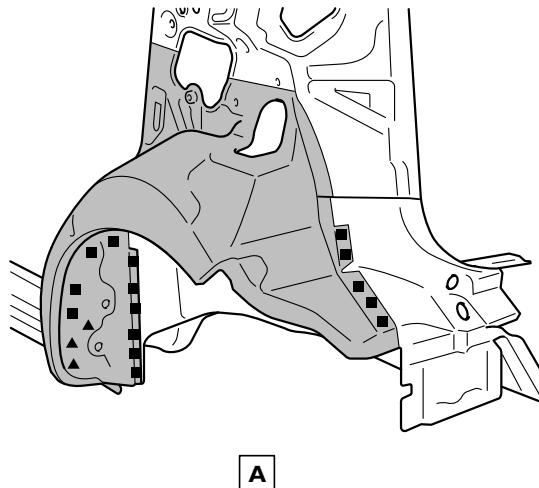


| Symbol | Operation description |
|---------|--|
| ● ● ● ● | Spot welding |
| ■ ■ ▲ ▲ | MIG plug welding (■ : indicates two panels to be welded ▲ : indicates three panels to be welded) |
| ++++ | MIG spot welding |
| | MIG arc welding (continuous) |
| oooo | Braze welding |
| | Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.) |

REPAIR WELDS



(With the quarter outer panel and fuel filler neck bracket removed)



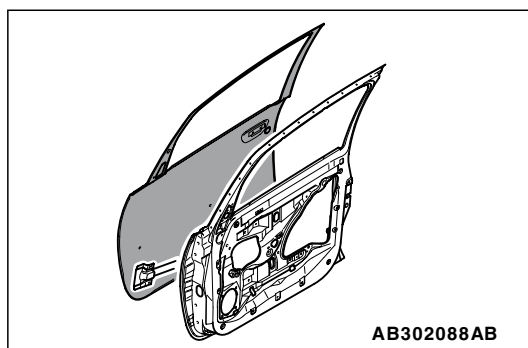
AB302145AB

NOTE:

- Refer to the quarter outer Section on [P.3-14](#) for the welding point with quarter outer panel and rear combination lamp housing panel.
- Refer to the quarter inner Section on [P.3-22](#) for the welding point with Fuel filler neck bracket.

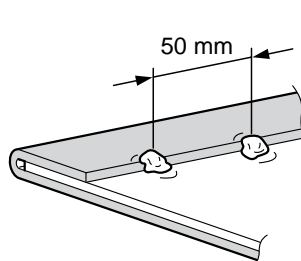
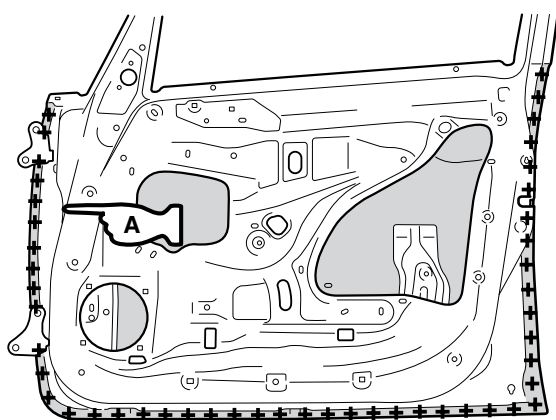
FRONT DOOR OUTER PANEL

M4030013000231

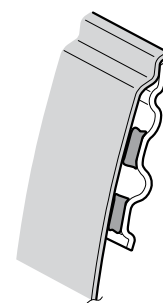


| Symbol | Operation description |
|---------|--|
| ● ● ● ● | Spot welding |
| ■ ■ ▲ ▲ | MIG plug welding (■ : indicates two panels to be welded ▲ : indicates three panels to be welded) |
| ++++ | MIG spot welding |
| +++++ | MIG arc welding (continuous) |
| oooo | Braze welding |
| | Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.) |

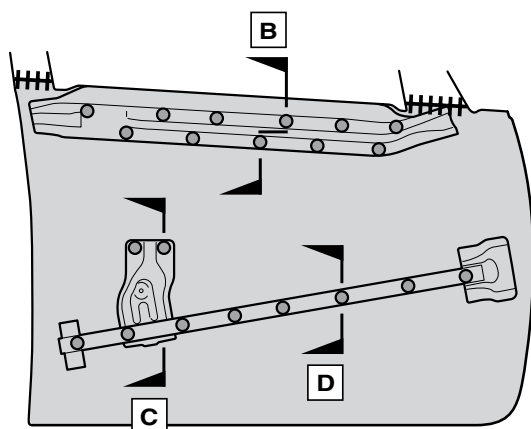
REPAIR WELDS



A

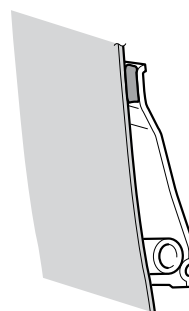


B

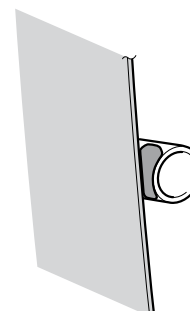


C

D



C



D

: Adhesive

- Adhesive : Urethane body sealer
Brand:
3M ATD Part No.8542 or equivalent

NOTE: After hemming the front door outer panel,
MIG spot weld the flange overlap section at a pitch of
50 mm.

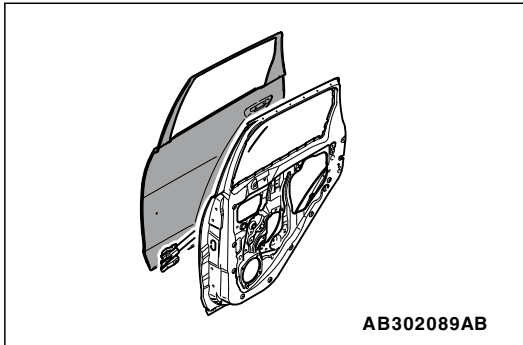
NOTE ON REPAIR WORK
REMOVAL

Cut the door outer panel from the bottom of the
window sash, and replace it.

AB302108AB

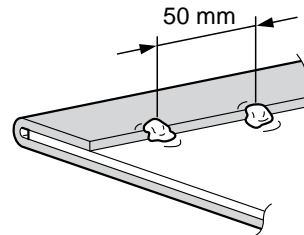
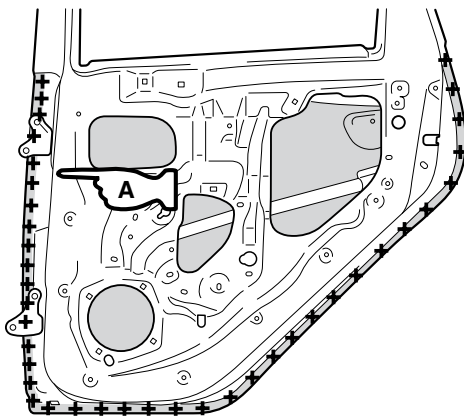
REAR DOOR OUTER PANEL

M4030014000223

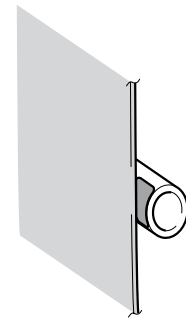
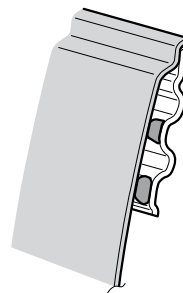
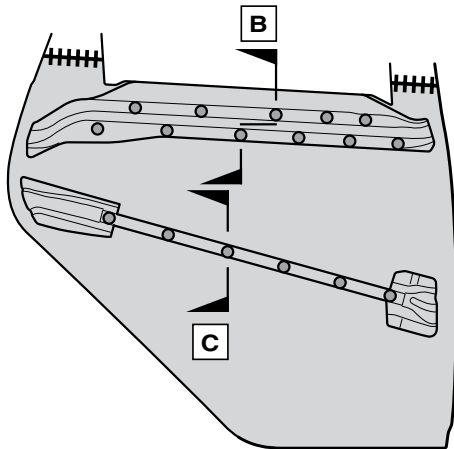


| Symbol | Operation description |
|---------|--|
| ● ● ● ● | Spot welding |
| ■ ■ ▲ ▲ | MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded) |
| ++++ | MIG spot welding |
| +++++ | MIG arc welding (continuous) |
| oooo | Braze welding |
| | Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.) |

REPAIR WELDS



A



: Adhesive

- Adhesive : Urethane body sealer
Brand:
3M ATD Part No.8542 or equivalent

*NOTE: After hemming the rear door outer panel,
MIG spot weld the flange overlap section at a pitch of
50 mm.*

NOTE ON REPAIR WORK REMOVAL

Cut the door outer panel from the bottom of the
window sash, and replace it.

AB302109AB